Piate: User:

Tuesday, 23/09/2008 1:00:22 PM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number **Estimate Number** : 42256

: 12728

P.O. Number

This Issue : 23/09/2008

: NC Prsht Rev.

First Issue Previous Run

: 31993

: 11

Type

: SMALL /MED FAB

Project Number Drawing Revision

Drawing Number

Drawing Name

Part Number

Material

Due Date : 05/10/2008

: WEARSHOE

: D353541

: N/A

: D3535 REV B

Qty:

12 Um:

Each

Checked & Approved By

Comment

Written By

New Issue 07-02-15 JLM : Est Rev:A

Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304/316 .040 Sheet

1.0

M304S20GA

Comment: Qty.:

0.5355 sf(s)/Unit

Total:

6.4260 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch:

图 8-11-5

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev:_

Prog Rev:_

HB8-11-5

2-Deburr if necessary

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



188-11-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NO

NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

SB 08/10/05

W/O:			WORK ORDER CHANGES									
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector					
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Tuesday, 23/09/2008 1:00:22 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: WEARSHOE Customer: CU-DAR001 Dart Helicopters Services Job Number: 42256 Part Number: D353541 Job Number: Seq. #: **Machine Or Operation:** Description: Form Joggle on brake using Jig DT8158 as per Dwg D3535 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 7.0 **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE FINISH TIME** INSPECT POWDER COAT/CHEMICAL CONVERS 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: HP-10.0 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

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Description: Wearshoe	Part Number: D3535-4	1				
Inspection Dwg: D3535 Rev: B	Page 1 of	1				

FIRST ARTICLE INSPECTION CHECKLIST

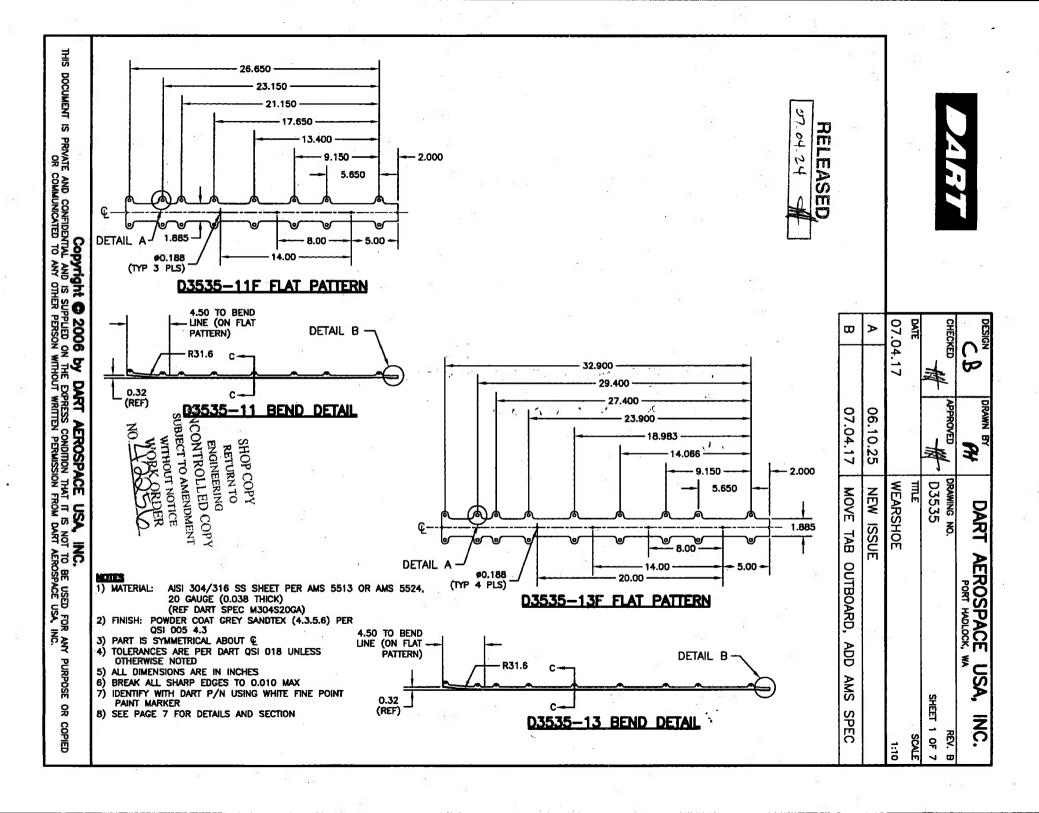
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Rev	Date	Change	Revised by	Approved
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Dart Aerospace Ltd W/O: WORK ORDER CHANGES **Approval Approval** DATE STEP PROCEDURE CHANGE By Date Qtv Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE STEP Sign & Initial **Action Description** Section A QC Inspector Section C Chief Ena Chief Ena Chief Eng Date

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07.04.17

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DRAWING NO. D3535

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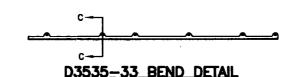
22.500 19.000 9.500 6.000 2.000 1.885 DETAIL A #0.188 (TYP 3 PLS) D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

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0.188 (TYP 3 PLS)
D3535-33F FLAT PATTERN



NOTES 1) MATERIAL:

PURPOSE

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AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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5 OF 7

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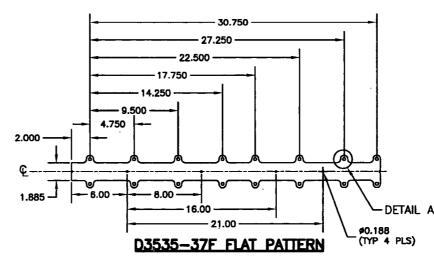
23.250 19.750 17.750 14.250 4.750 2.000 #0.188 (TYP 2 PLS) 1.885 -DETAIL A

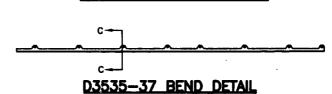
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- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



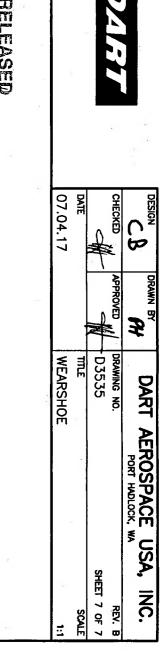


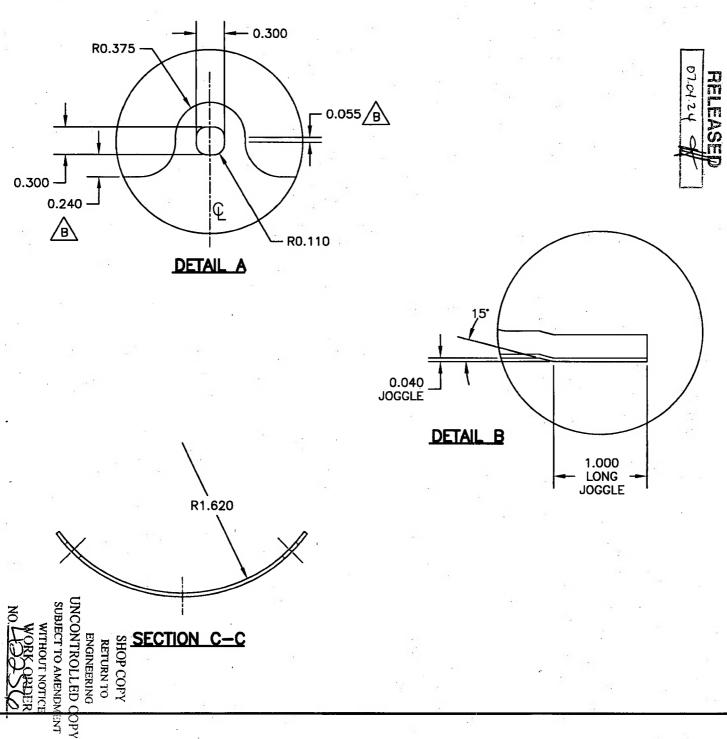
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